

Work Order ID 133787

Wednesday, June 17, 2015 2:52:34 PM

133787

U/R

N/A

Page 1

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: ~~133787~~ *N/A* Stop ***NS2***
 Item Name: Saddle, Inboard RH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: JUN 17 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3884	C

100	HAAS CNC VERTICAL MACHINING #1	0.00				8	Ø	DAS 40 9-89	DAS 20 9-89 1507-27
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>133787</u> Double check by: <u>LL</u> 1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets							15/07/24	
110	QC2- Inspect parts off machine FAI/FAIB	0.00				8	Ø	DAS 40 9-89	DAS 20 9-89 1507-27
110									
QC	Memo	0.00							
Quality Control								15/07/24	

Work Order ID 133787

133787

Page 2

Wednesday, June 17, 2015 2:52:34 PM

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R Stop ***NS2***
 Item Name: Saddle, Inboard RH
 Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 08 9-89
120 QC Quality Control	Memo	0.00		15/07/27		8	0		
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130 HandFinish Hand Finishing	Memo	0.00				8	0	15-8-12	

Work Order ID 133787

Wednesday, June 17, 2015 2:52:34 PM

133787

Page 3

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Saddle, Inboard RH
Start Date: 6/17/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 6/17/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

Powder Coating

Memo

0.00

***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF
POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)***

1113 1545

DO NOT MASK INSIDE FLANGE SURFACE

START TIME:

8:30 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00 AM

28 of 111 13/09/15

150

QC3- Inspect Part Finish

0.00

150

QC

Quality Control

Memo

0.00

8

DAS
38
9-88

AUG 17 2015

Wednesday, June 17, 2015 2:52:34 PM

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle, Inboard RH

Start Date: 6/17/2015 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 6/17/2015 **Req'd Qty:** 8.00

g

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Identify as per dwg & Stock Location: ST404

0.00

160

Packaging

Memo

0.00

DAS
26
9-89

⑧

JA

AUG 17 2015

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLX

AUG 17 2015

MS-8.17

Picklist Print

Wednesday, June 17, 2015 2:52:37 PM

Page 1

Work Order ID: 133787

133787

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inboard RH

Start Date: 6/17/2015

Required Date: 6/17/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017		Manufactured	No				Each	4.0000		8			DAS
D6101-017									**			15/07/21	40
Saddle Billet													9-89

Location

Loc Qty

Loc Code

MAT044

4

→ 129915

4

→ 133963

3
5

DART AEROSPACE LTD		Work Order:	133787
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.645	.644	.644	.640		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.611	.610	.609	.609		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.500	2.500	2.500	2.500		
I	2.000	2.020		2.0024	2.0031	2.0024	2.0033		
J	0.140	0.175		.150	.146	.144	.145		
K	1.265	1.285		1.2674	1.2681	1.2674	1.2683		
L	0.115	0.135		.126	.124	.124	.124		
M	0.240	0.260		.251	.249	.247	.247		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.248	.240	.253	.252		
P	2.826	2.886		2.855	2.855	2.855	2.855		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.153	.150	.155	.154		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.260	1.260	1.260	1.260		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.002	6.000	6.000	6.000		
W	2.495	2.505		2.506	2.500	2.500	2.500		
X	0.490	0.510		.497	.499	.498	.497		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.216	.219	.219	.218		
AC	0.316	0.321		.317	.317	.317	.317		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.002	1.000	1.003	.999		
AF									

Accept/Reject

DAS

DAS

20

Measured by:	40	15-07-27
Date:	15-07-24	

Audited by:	H.A.
Date:	15/07/27

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	133787
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. B	Page 1 of 1	

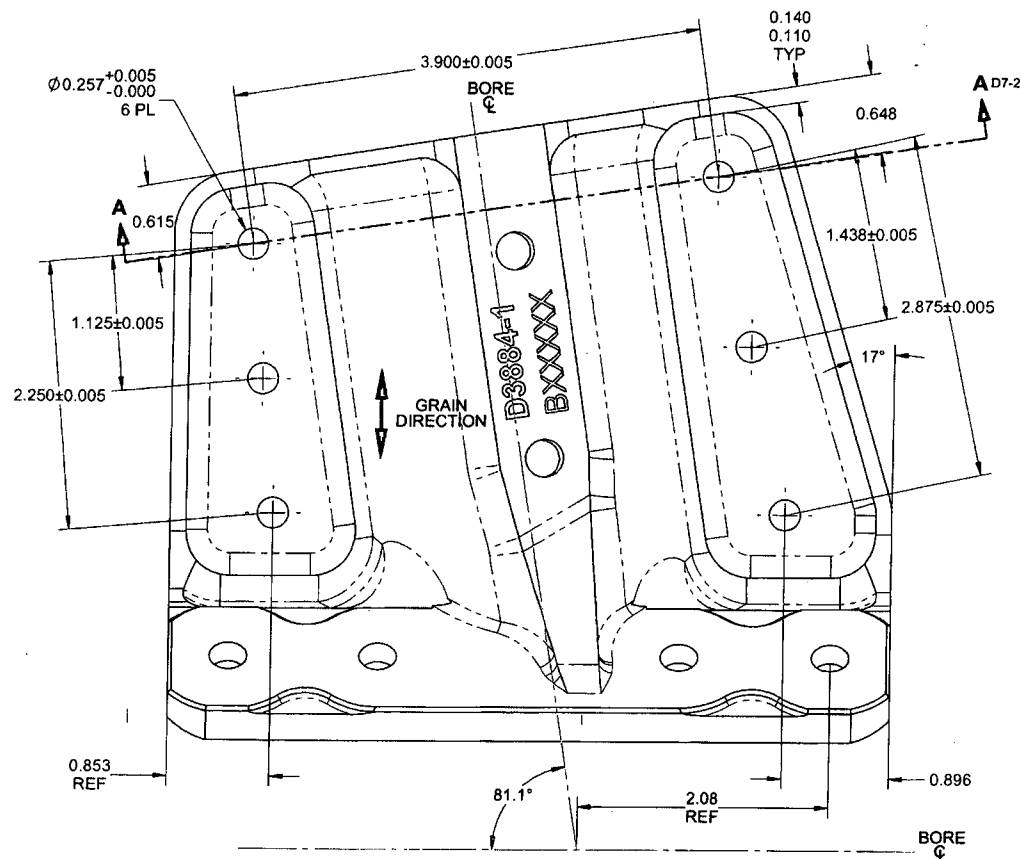
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 #	6 #	7 #	8 #	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.645	.644	.642	.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.609	.608	.608	.609		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.0030	2.0025	2.003	2.0025		
J	0.140	0.175		.149	.145	.145	.145		
K	1.265	1.285		1.2680	1.2675	1.268	1.2675		
L	0.115	0.135		.124	.123	.123	.125		
M	0.240	0.260		.248	.247	.248	.247		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.252	.254	.252	.251		
P	2.826	2.886		2.855	2.855	2.855	2.855		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.154	.154	.154	.154		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.260	1.260	1.260	1.260		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.498	.500	.4985	.498		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.220	.218	.219	.219		
AC	0.316	0.321		.317	.317	.317	.317		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.002	1.000	1.000	1.000		
AF									
Accept/Reject									
DAS									

Measured by:	20	15-07-27
Date:	8-89	

Audited by:	D.E	DAS
Date:	15/07/27	08
		8-89

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

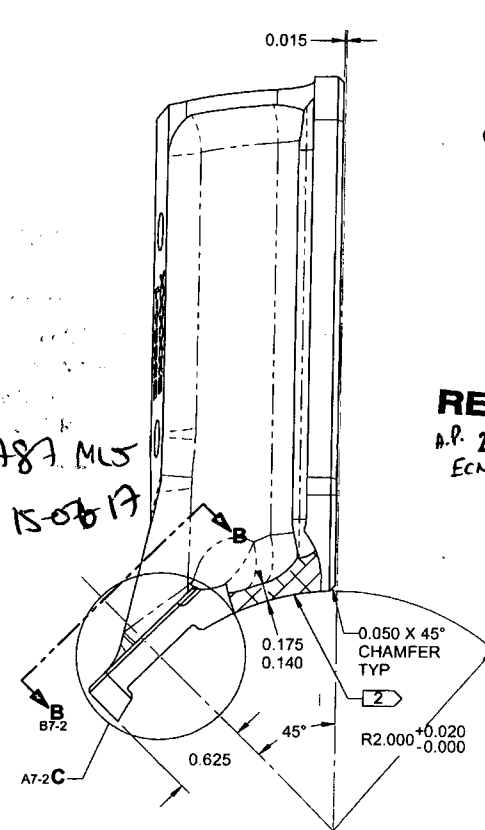


D3884-1 SADDLE, INBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-1-REVC.SLDPRT"

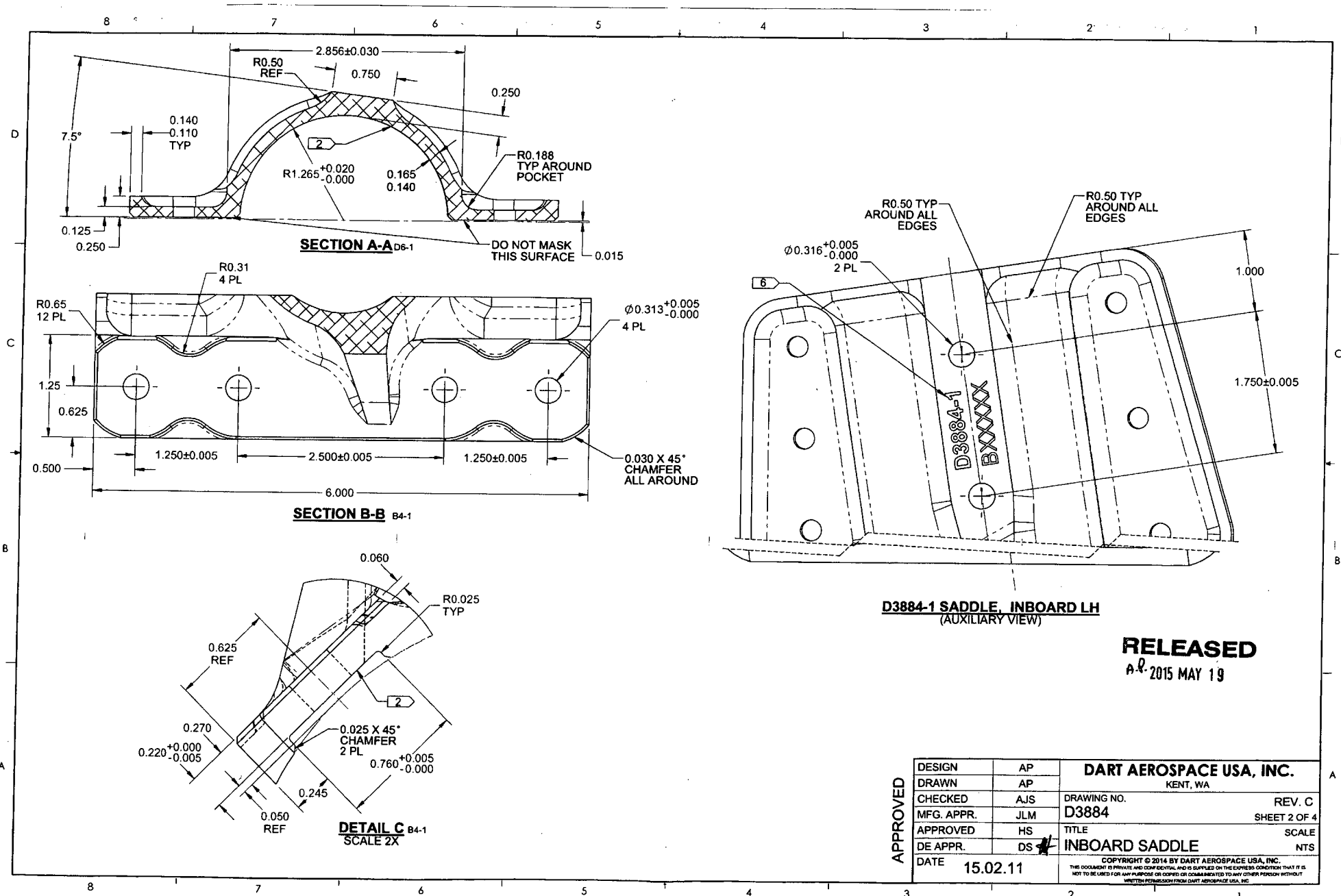
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER NO. 133387 ML5
15-08-17



RELEASED
R.P. 2015 MAY 19
ECN15-575

C	GENERAL REDRAW & REMOVED UNNECESSARY DIMS: ADDED NOTE 9, REMOVED POWDER COAT FROM INSIDE SURFACE OF D3884-1/2, ADDED D3884-2 TO SHT 3 & 4.	AP	15.02.11
B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE ZN C4-2; ADD R0.031 ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165 ZN B7-1; ADD 0.615 ZN C6-1; ADD 0.648 ZN C4-1; ADD 0.250 ZN D6-2; ADD 0.080 ZN C2-2; 0.75 WAS 0.65 ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. REV. C	
MFG. APPR.	JLM	D3884 SHEET 1 OF 4	
APPROVED	HS	TITLE SCALE	
DE APPR.	DS	INBOARD SADDLE NTS	
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

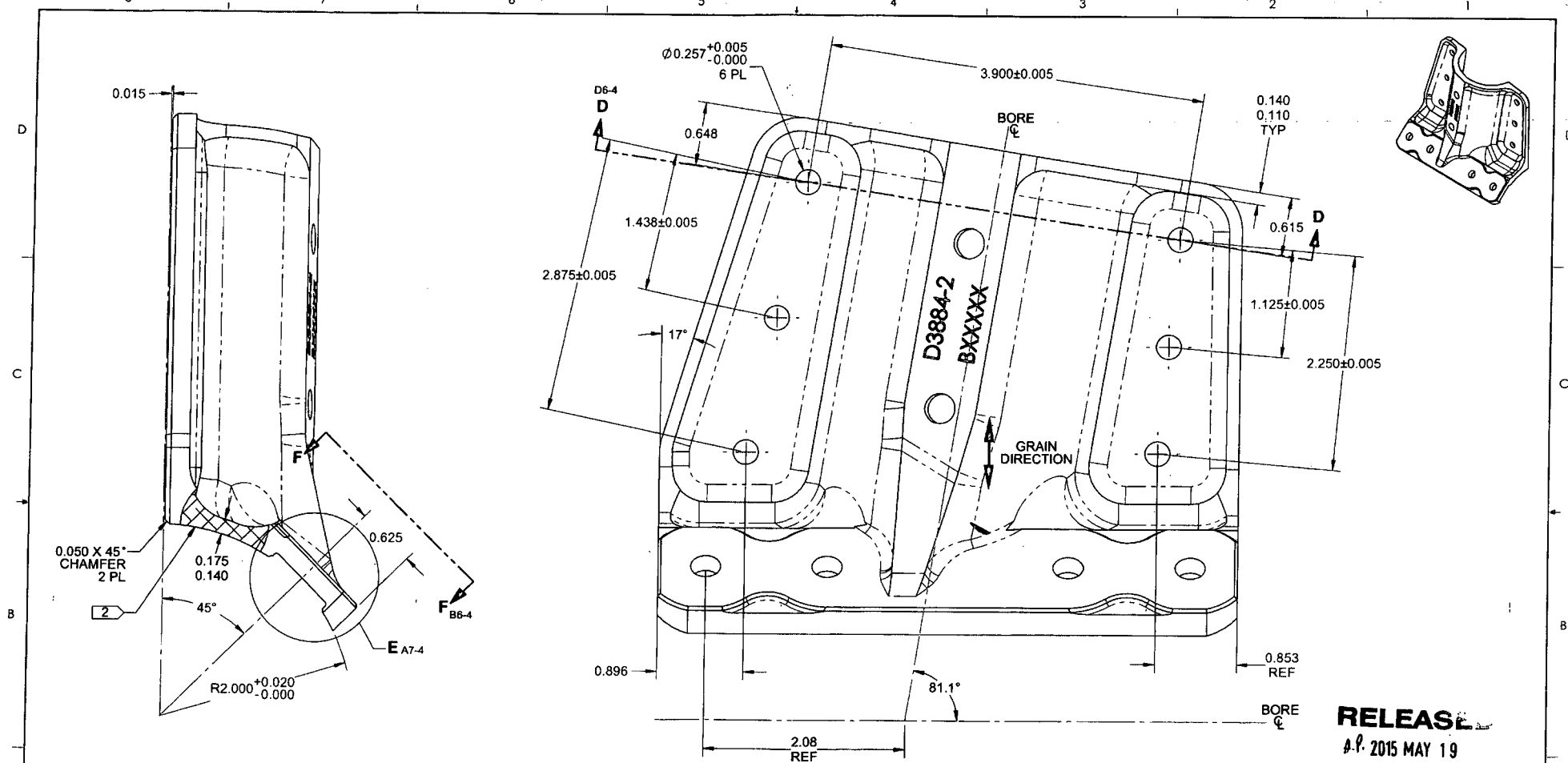
APPROVED



D3884-1 SADDLE, INBOARD LH
(AUXILIARY VIEW)

RELEASED
A.R. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
	DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3884-2 SADDLE, INBOARD RH

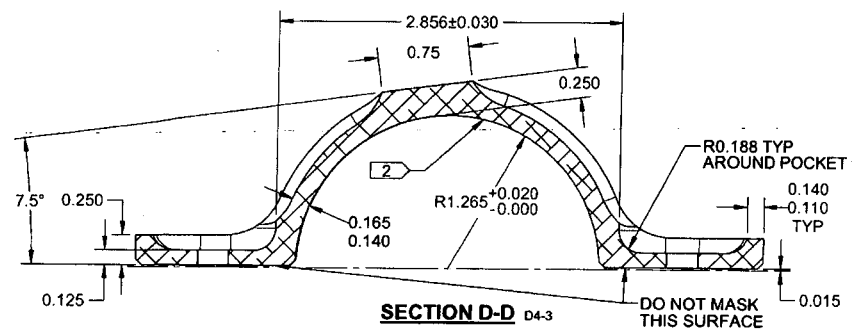
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-2-REV.C.SLDPR" T

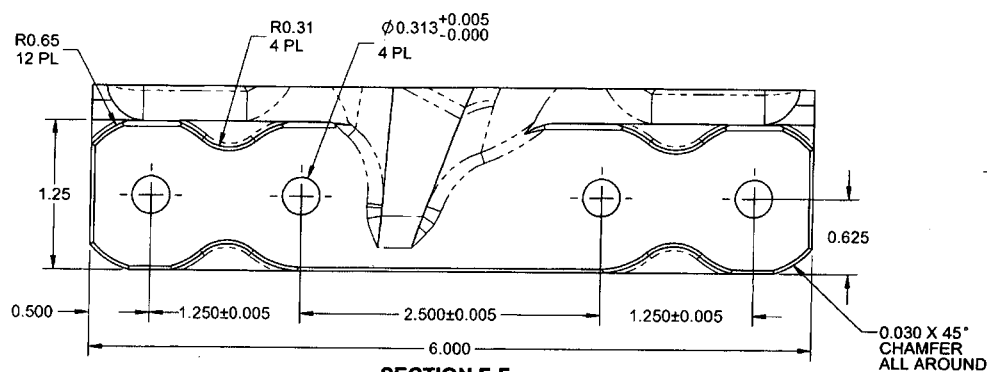
APPROVED

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3884	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	INBOARD SADDLE	NTS
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

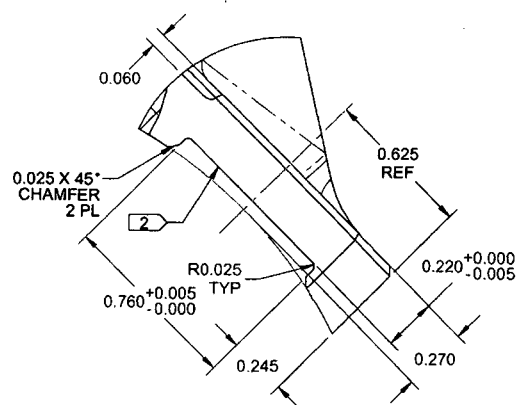
RELEASE
A.P. 2015 MAY 19



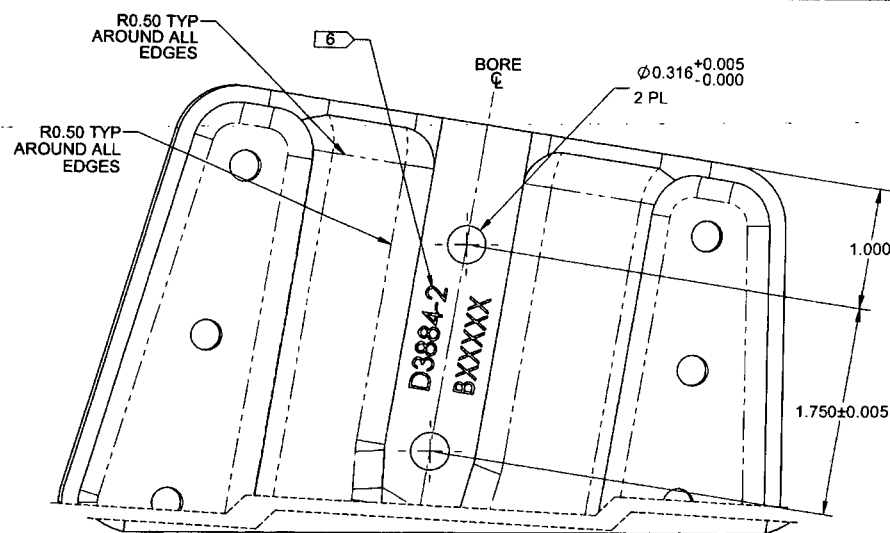
SECTION D-D D4-3



SECTION F-F B7-3



DETAIL E B7-3



D3884-2 SADDLE, INBOARD RH
(AUXILIARY VIEW)

RELEASED

A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
DATE		15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	